

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013447**Date Inspected:** 19-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

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This QA inspector observed ZPMC qualified welding personnel identified as 062761 perform Flux Cored Arc Welding (FCAW) Welding on USPL1, weld joint identified as USPL1-518-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062807 perform FCAW Welding on USPL1, weld joint identified as USPL1-519-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 060752 perform FCAW Welding on USPL1, weld joint identified as USPL1-520-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062783 perform FCAW Welding on

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USPL1, weld joint identified as USPL1-521-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 062786 perform FCAW Welding on USPL1, weld joint identified as USPL1-522-001 and 002. ZPMC QC is identified as Mr. Zhou Cheng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

### Outside Yard 10BE

This QA inspector observed ZPMC qualified welding personnel identified as 037996 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 10BE, weld joint identified as OBE1D-015. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 054013 perform SMAW Welding on OBG Segment 10BE, weld joint identified as OBE1D-016. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

### Outside Yard 9DW

This QA inspector observed ZPMC qualified welding personnel identified as 066002 perform SMAW Welding on OBG Segment 9DW, weld joint identified as SEG055D-019. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair, which is used as per Welding Repair Report (WWR) B-WR12046.

This QA inspector observed ZPMC qualified welding personnel identified as 0307870 perform SMAW Welding on OBG Segment 9DW, weld joint identified as SEG055D-164. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-Repair, which is used as per Welding Repair Report (WWR) B-WR12046.

### Outside Yard 9EE

This QA inspector observed ZPMC qualified welding personnel identified as 054014 perform SMAW Welding on OBG Segment 9EE, weld joint identified as CA069-004. ZPMC QC is identified as Mr. Wang Xiang Pin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-4G (4F)-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1368.

### Visual Inspection after Blast

### OBG Segment 9CW

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This QA Inspector performed a preliminary random visual inspection after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 200113 perform Shielded Metal Arc Welding (SMAW) Welding on OBG Segment 12AE, weld joint identified as FB3030-001-012 and 014. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 058551 perform FCAW Welding on OBG Segment 12AE, weld joint identified as FB3030-001-016. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 058551 perform FCAW Welding on OBG Segment 12AE, weld joint identified as FB3030-001-009 and 010. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233.

This QA inspector observed ZPMC qualified welding personnel identified as 214945 perform FCAW Welding on OBG Segment 12AE, weld joint identified as SEG3001X-003. ZPMC QC is identified as Mr. Guo Xing Hui. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Kumar,Vibin       | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | McClendon,Timothy | QA Reviewer                 |

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